

Date: Tuesday, 6/13/2006 3:28:56 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLEVIS
Job Number	: 27522		
Estimate Number	: 10104		
P.O. Number	: N/A	Part Number	: D2012107
This Issue	: 6/13/2006 S.O. No. : N/A	Drawing Number	: D2012-107 REV. C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 6/12/2006 Type : PURCHASED PARTS	Drawing Revision	: C
Previous Run	: 25483	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 6/30/2006
Checked & Approved By	: <u> </u>	Qty:	100 Um: Each
Comment	: Est: D 01.11.08 Re-format, Drawing to Rev. C SM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

MM OB OB 14 (100)

2.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0300 sf(s)/Unit Total: 3.0000 sf(s)
 304/316 .063 Sheet

MM 7106 MM OB OB 14

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

M.F. 06-06-19

6.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Form on press using DT8242 as per Dwg D2012-107

H-M 06/06/20

19052
19059
100
Attached 06-06-19

Date: Tuesday, 6/13/2006 3:28:56 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 27522

Part Number: D2012107

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

SECOND CHECK



Comment: SECOND CHECK

SB 06/06/20

(100)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

See Attached.

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/06/21

(100)

Job Completion



U 06.06.21

Date: Monday, 6/12/2006 3:43:15 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLEVIS
Job Number : 27522	
Estimate Number : 10104	
P.O. Number :	Part Number : D2012107
This Issue : 6/12/2006 S.O. No. :	Drawing Number : D2012-107 REV. C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : C
Previous Run : 25483	Material :
Written By :	Due Date : 6/30/2006 Qty: 100 Um: Each
Checked & Approved By :	
Comment : Est: D 01.11.08 Re-format, Drawing to Rev. C SM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

PG

PURCHASING

**Comment:** PURCHASING

Issue P/O:

E-mail or Ship DXF file to vendor

Laser cut flat pattern as per DXF file

Material release note is required.

Water Plot
 Dwg Rev: C
 Proj Rev: C

M 7106

M 06 06 14 (100)

2.0

D2012107F

Clevis

**Comment:** Qty: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

CLEVIS

M 06 06 14 (100)

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

06-06-15 (100)

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/06/12

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 3:43:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 27522

Part Number: D2012107

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form on press using DT8242 as per Dwg D2012-107

7.0

QC# 5

SECOND CHECK



Comment: SECOND CHECK

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST016

C700120106

(100)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

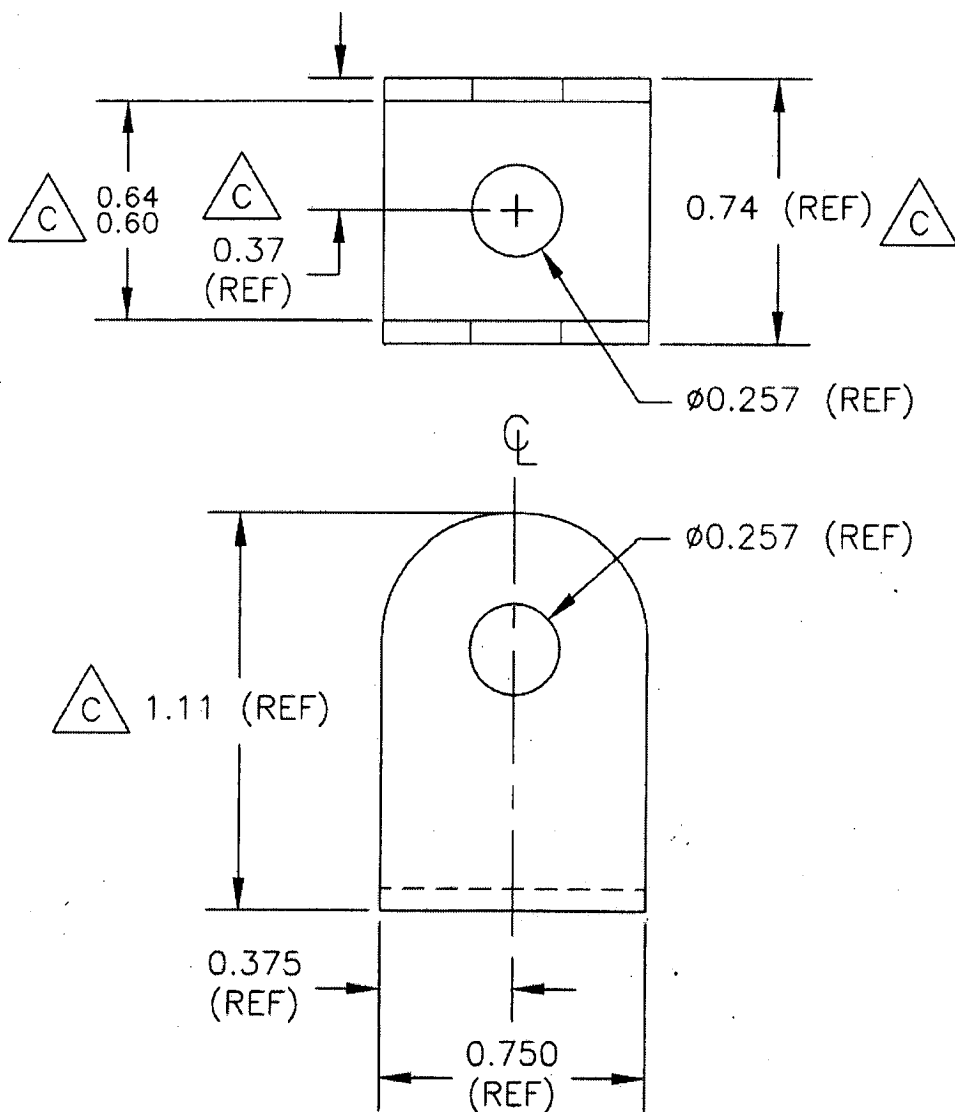
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2012-107	REV. C SHEET 1 OF 2
DATE 99.12.20		TITLE CLEVIS	SCALE 2:1
A	94.10.27	NEW ISSUE	
B	99.04.30	ADD FLAT PATTERN	
C	99.12.20	0.74 WAS 0.680	

RELEASED
00.01.04 PS



MATERIAL: AISI 304/316 SS 0.063 THICK

USE 0.032 BEND RADIUS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

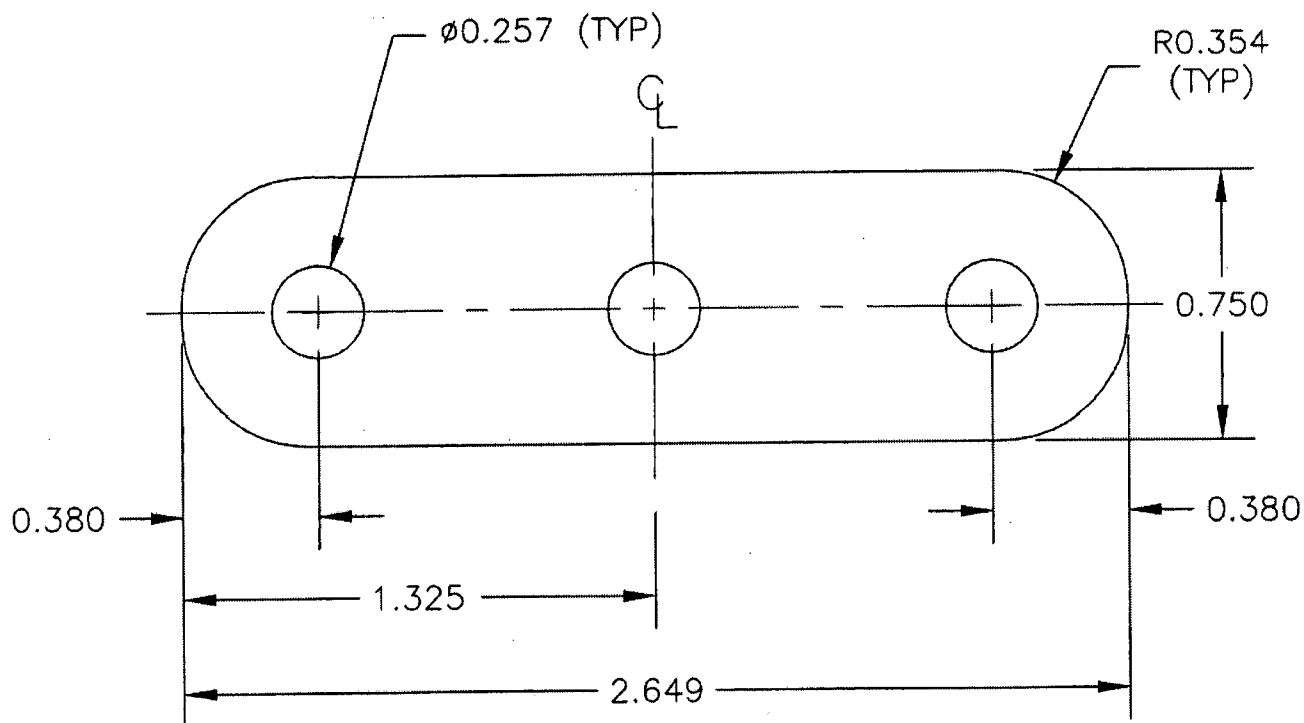
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27522



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2012-107	REV. C SHEET 2 OF 2
DATE 99.12.20		TITLE CLEVIS	SCALE 2:1

RELEASED
00-01-04 DS



D2012-107 FLAT PATTERN

MATERIAL: AISI 304/316 SS 0.063 THICK
TOLERANCES ARE DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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